

Work Order ID 161594

Thursday, May 25, 2017 3:18:23 PM

Page 1

ASAP PLS *161594*

Item ID: D3407-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Ring

Start Date: 5/30/2017 Start Qty: 40.00

40

Cust Item ID:

Required Date: 6/5/2017 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: **DAS** Date: **MAY 26 2017**

Tooling: Date:

Run Start ***NR1***QC: **21** Date: **9-89** SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3407	Rev E

100

0.02

100

FLOW WATER JET

Waterjet

Memo

1.95

FLOW CNC Waterjet

1-Cut as per Dwg D3407

Dwg Rev: **E**Prog Rev: **E**

2-Break edges on manual lathe Dwg D3407 (175rpm)

(28)**05/17/2017**

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.80

Quality Control

(28)**05/17/2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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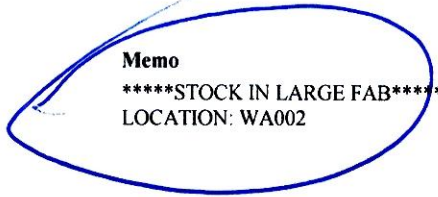
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115 *115* Lathe Conv Conventional Lathe	Manufacture as per dwg Memo	0.00 2.33				<u>28</u>	<u>✓</u>		DAS 32 9-89 17-07-13
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.80				<u>28</u>	<u>✓</u>		DAS 49 9-89 17/07/15
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo *****STOCK IN LARGE FAB***** LOCATION: WA002	0.00 4.00				<u>28</u>		JUL 18 2017	DAS 6 9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21 - Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.40							
Quality Control									

DAS
21
9-89

JUL 18 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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OTHER : ☐					

Picklist Print

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161594

Parent Item: D3407-5

D3407-5

Parent Item Name: Ring

Start Date: 5/30/2017

Required Date: 6/5/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 05-11-22 JLM
IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174B0.250X4.000		Purchased	No			100	f	15.5000	0.2666	11.22526			
M174B0 250X4 000									**				
17-4 BAR 0.250" X 4.000"													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT051		15.5					
						m136304		3.5					
						m137447		12					
										7.3			

or 17/06/22

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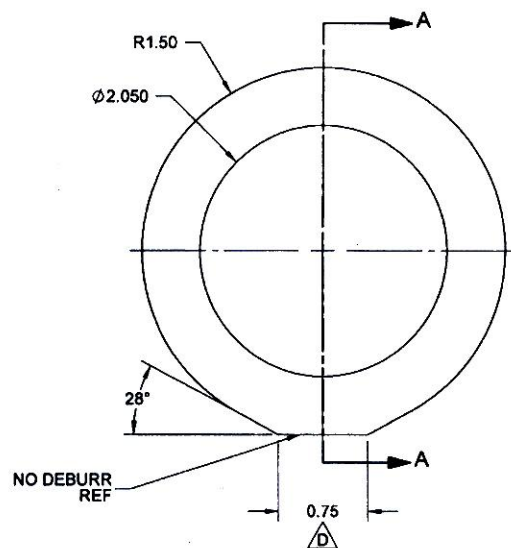


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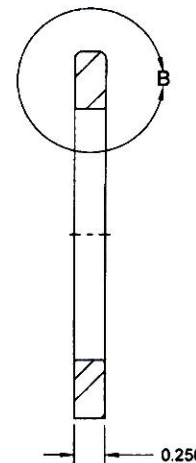
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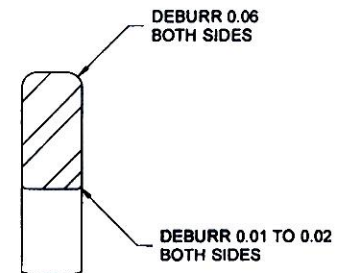
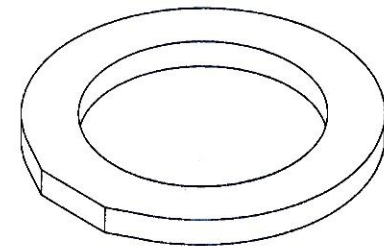
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161594
MJS
1705-26



D3407-5 RING



SECTION A-A



DETAIL B
SCALE 2X

RELEASED
08-08-2023

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	1/28	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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